

Date: Tuesday, 27/01/2009 11:11:55 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	EYE BOLT
Job Number :	45282		
Estimate Number :	11290		
P.O. Number :		Part Number :	D343711
This Issue :	27/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3437 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	39893	Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	10/02/2009
Written By :		Qty:	10
Checked & Approved By :	JW 09.01.27	Um:	Each
Comment :	Est. A 05.05.20 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0750	303 Round Bar 0.750
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Comment: Qty.: 0.2187 f(s)/Unit Total : 2.1872 f(s)
 303 Round Bar .75"
 Material : AISI 303 SS Round Bar Ø0.750"
 Dwg Rev: B
 (M303R0.750)
 Identify for D3437-11
 Batch: M110680

SA 09/02/06

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 Turn as per Folio FA528 & Dwg D3437 Folio Rev: N/A
 Deburr

SA 09/02/06

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/02/06

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONV MILLING MACHINE
 Machine as per Dwg D3437
 Deburr

See w/o change on back

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector
09-02-09	2.0	update the machine being used to the Doosan, and the turning & machining included. This will eliminate sequence 4.0 & 5.0, keeping the QC 8. Perm change.	<i>[Signature]</i>	09-02-11		<i>[Signature]</i> 09-02-09	<i>[Signature]</i> 09-02-09

Part No: D3437-11 PAR #: N/A Fault Category: Prod / Machine / Parts NCR: Yes No DQA: D Date: 09/02/11
 Resolution: Process change Disposition: Scrap QA: N/C Closed: D Date: 09/02/11

NCR: 45282		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/06	2.0	- .188 dimension under tolerance - 2 parts R.C. Endmill pulled out of collet while machining too long causing slight vibration & pull.	<i>[Signature]</i> 05/02/06	- change to shorter endmill - scrap & replace qty 2	<i>[Signature]</i> 07/02/06	<i>[Signature]</i> 09-02-06	<i>[Signature]</i> 05/02/06	<i>[Signature]</i> 09-02-06

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 11:11:55 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYE BOLT

Job Number: 45282

Part Number: D343711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MF 09/02/09

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SS 198

SS 09/02/09

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/09

Job Completion



MF 09-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

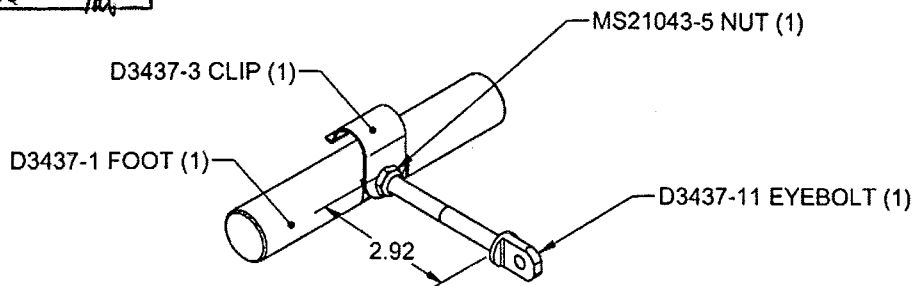
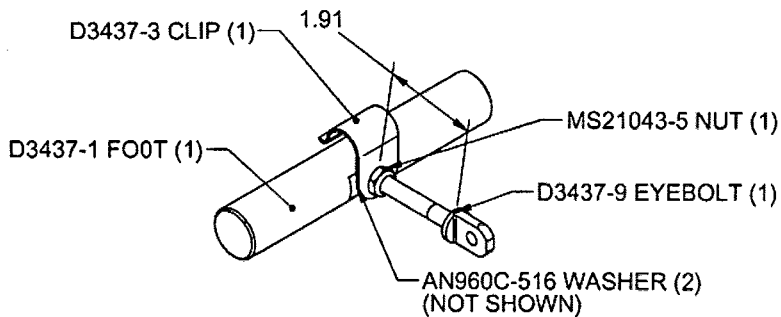
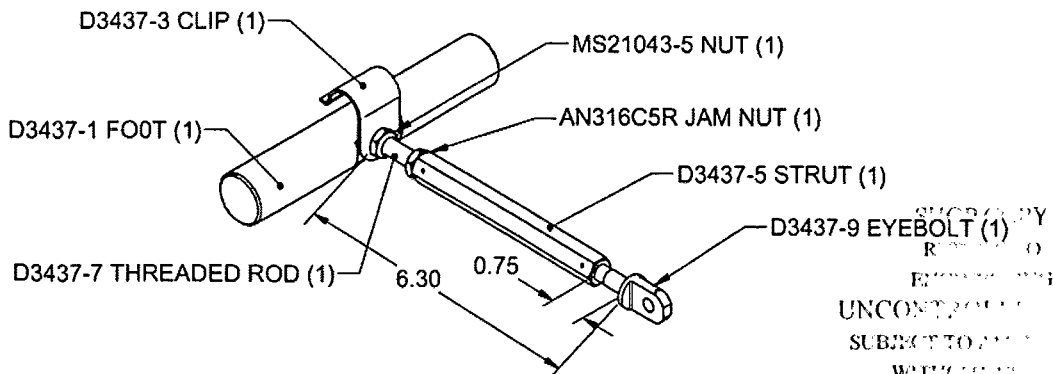
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 1 OF 4
DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

RELEASED05.08.16 *[Signature]***D3437-041 AFT STRUT ASSEMBLY****D3437-043 AFT STRUT ASSEMBLY****D3437-045 AFT STRUT ASSEMBLY**

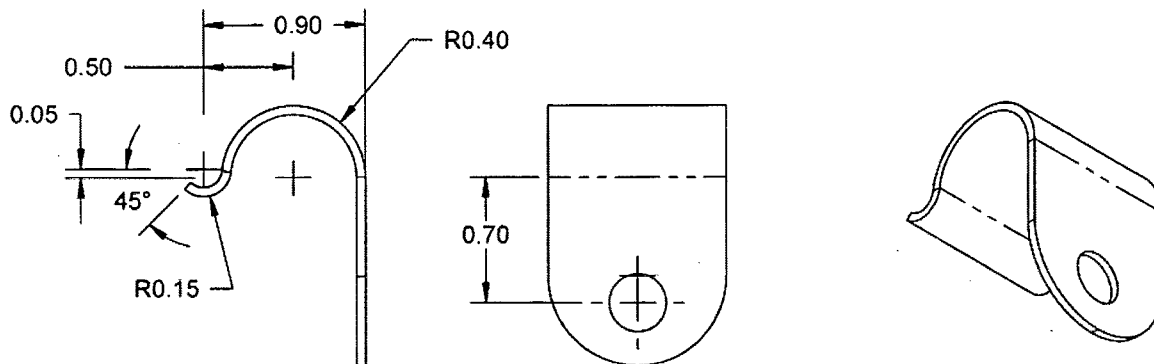
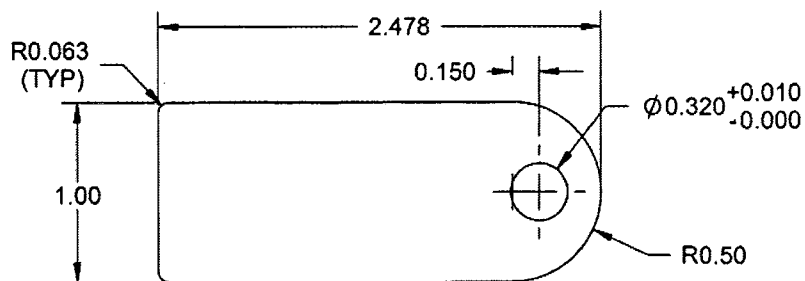
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2

RELEASED05.08.16 *[Signature]***D3437-3 CLIP**
SCALE 1:1**D3437-3**
FLAT PATTERN**D3437-3 CLIP:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

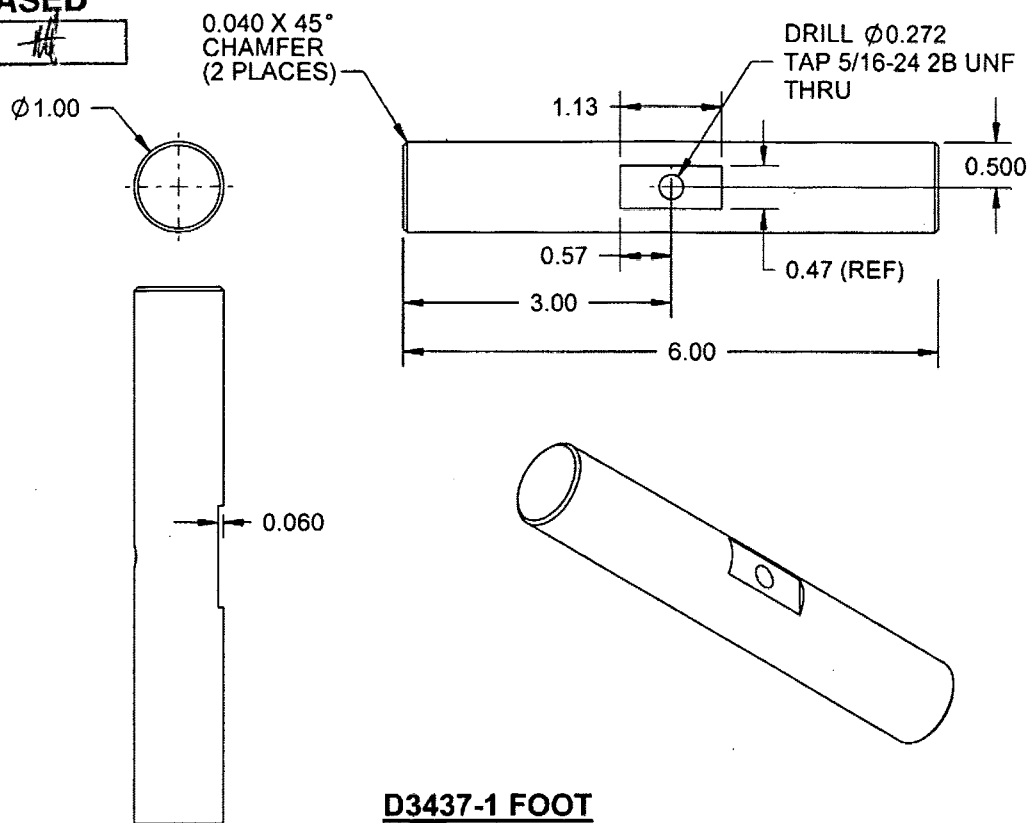
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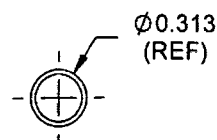
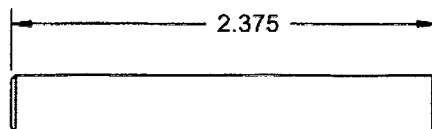
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DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

RELEASED05.08.16 *[Signature]***D3437-1 FOOT****D3437-1 FOOT:**

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR
(REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**D3437-7 THREADED ROD****D3437-7 THREADED ROD:**

- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

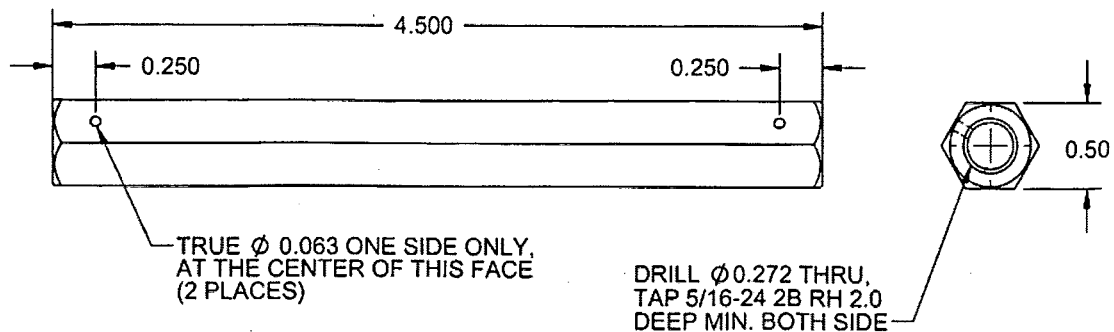
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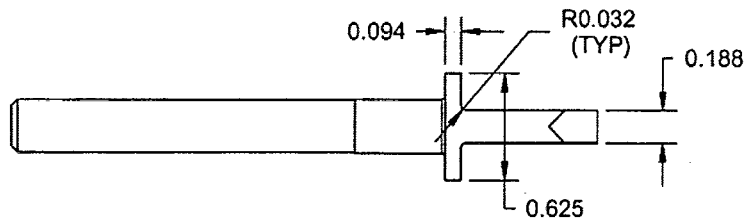
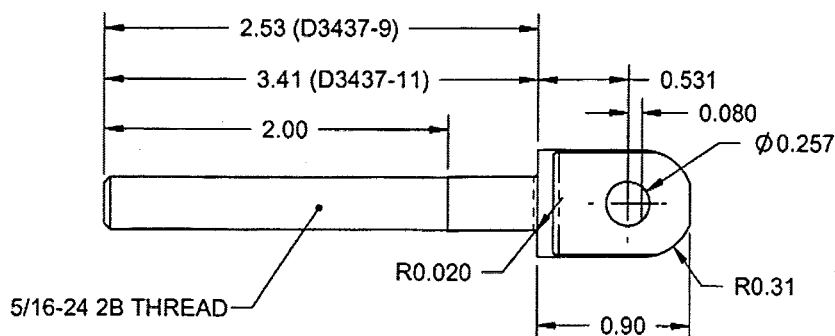
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DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

**D3437-5 STRUT:**

- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**RELEASED**05-08-16 *[Signature]***D3437-9/-11 EYEBOLT:**

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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